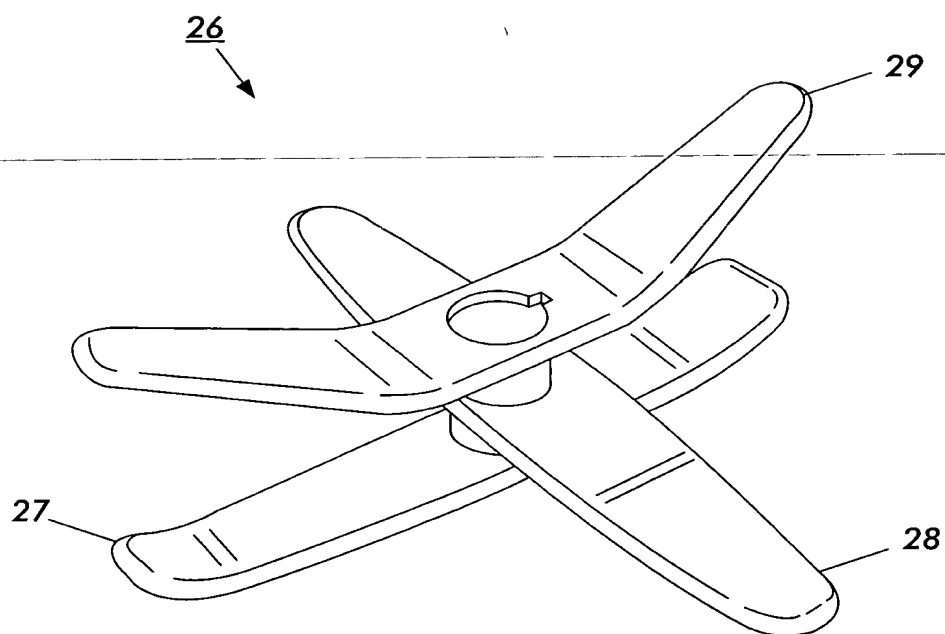
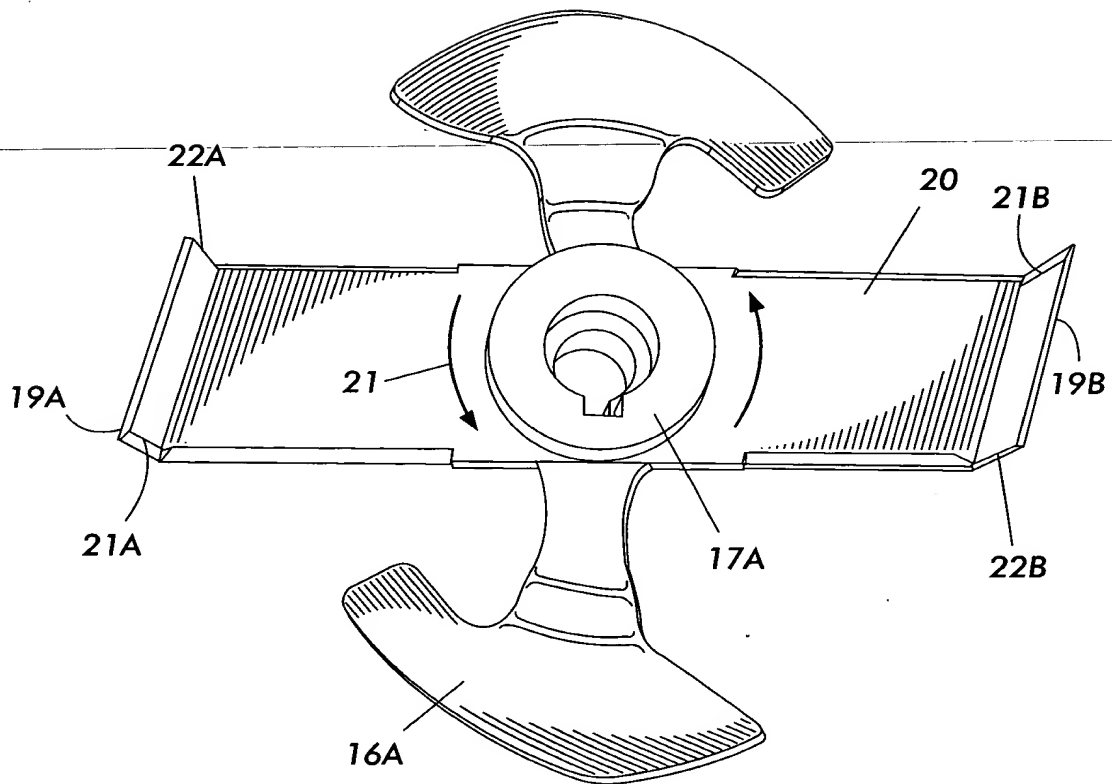


**FIG. 1**  
PRIOR ART



**FIG. 2**  
PRIOR ART



**FIG. 3**  
PRIOR ART

FIG. 4

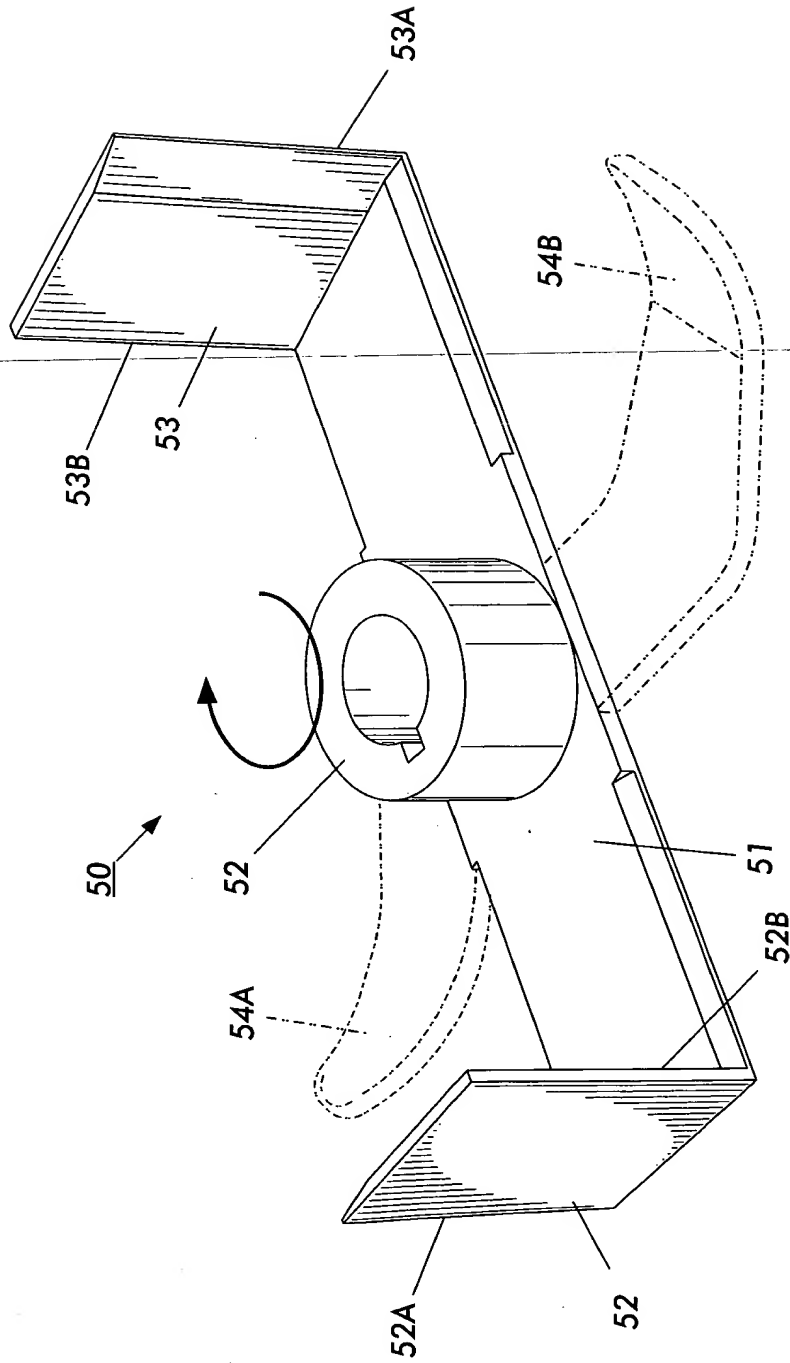


FIG. 4

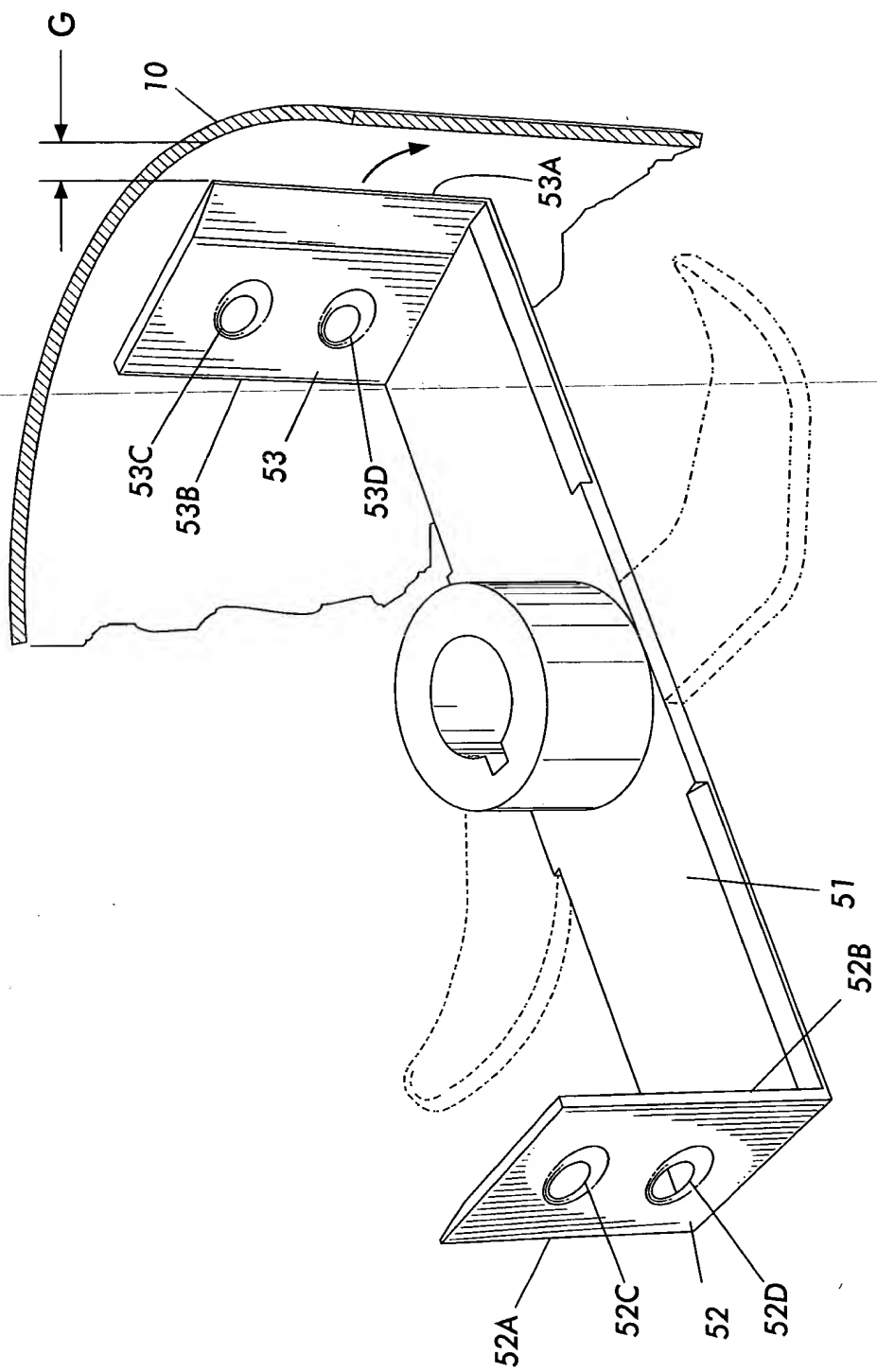


FIG. 5

6/11

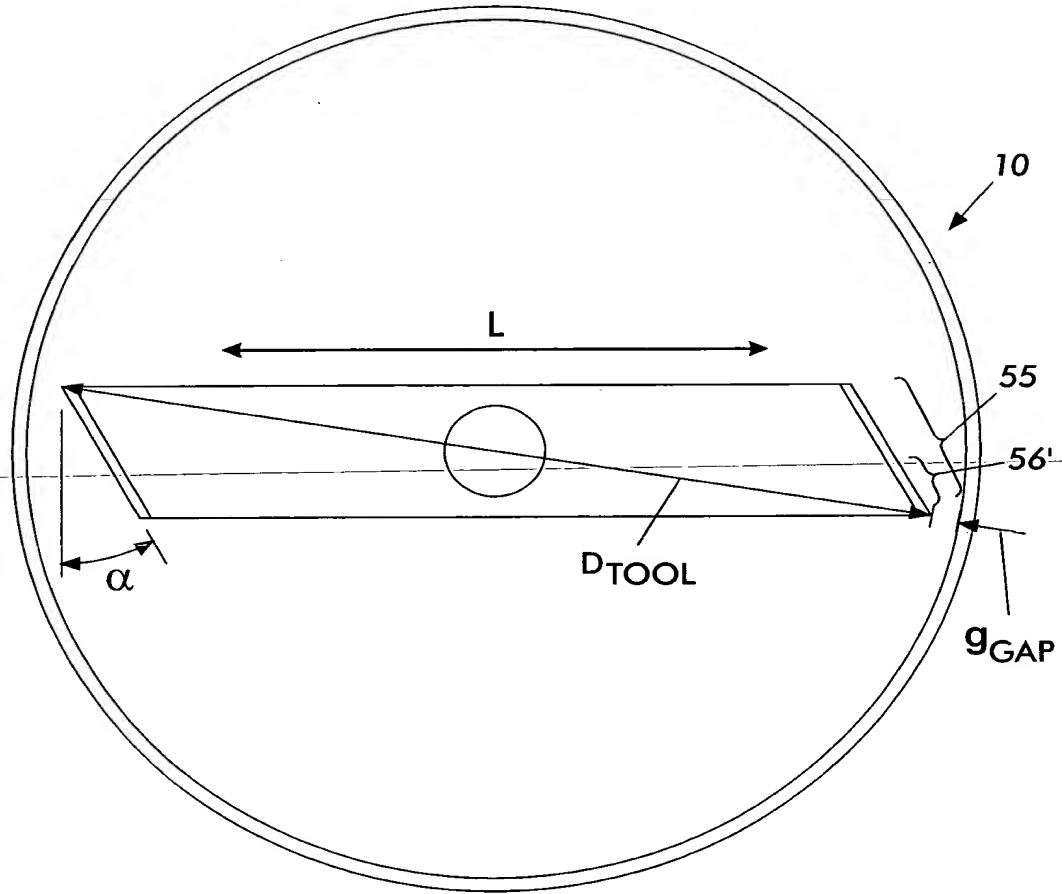


FIG. 6

	$H_{\text{TOOL}}$ mm	$W_{\text{TOOL}}$ mm	$\alpha$ DEGREES	$D_{\text{TOOL}}$ mm	$g_{\text{GAP}}$ mm
TOOL 50	63	53	15	220	5
LITTLEFORD	40	53	17	217	6.5

FIG. 7

FIG. 6

T01E30-TS6ETH60

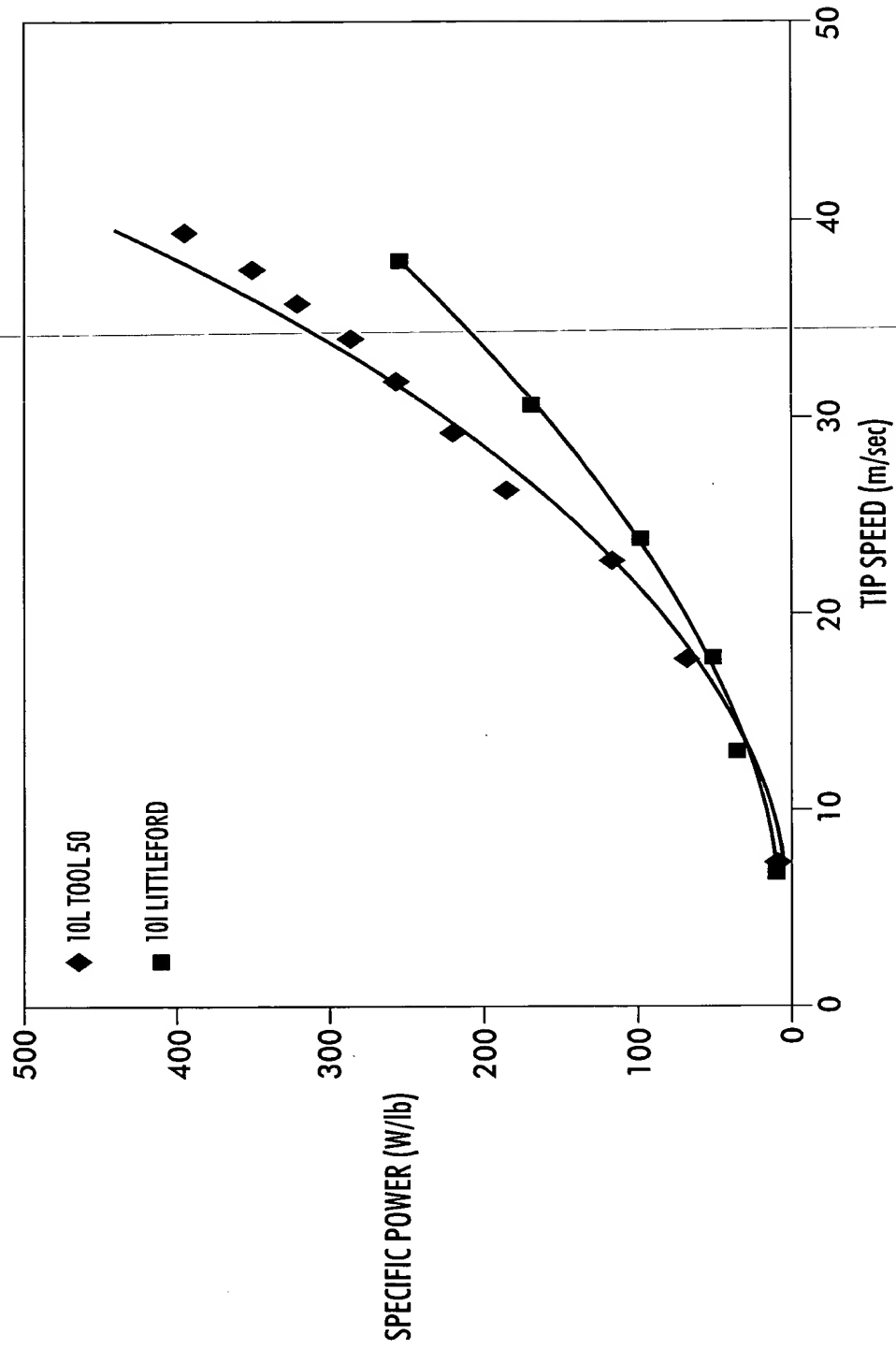


FIG. 8

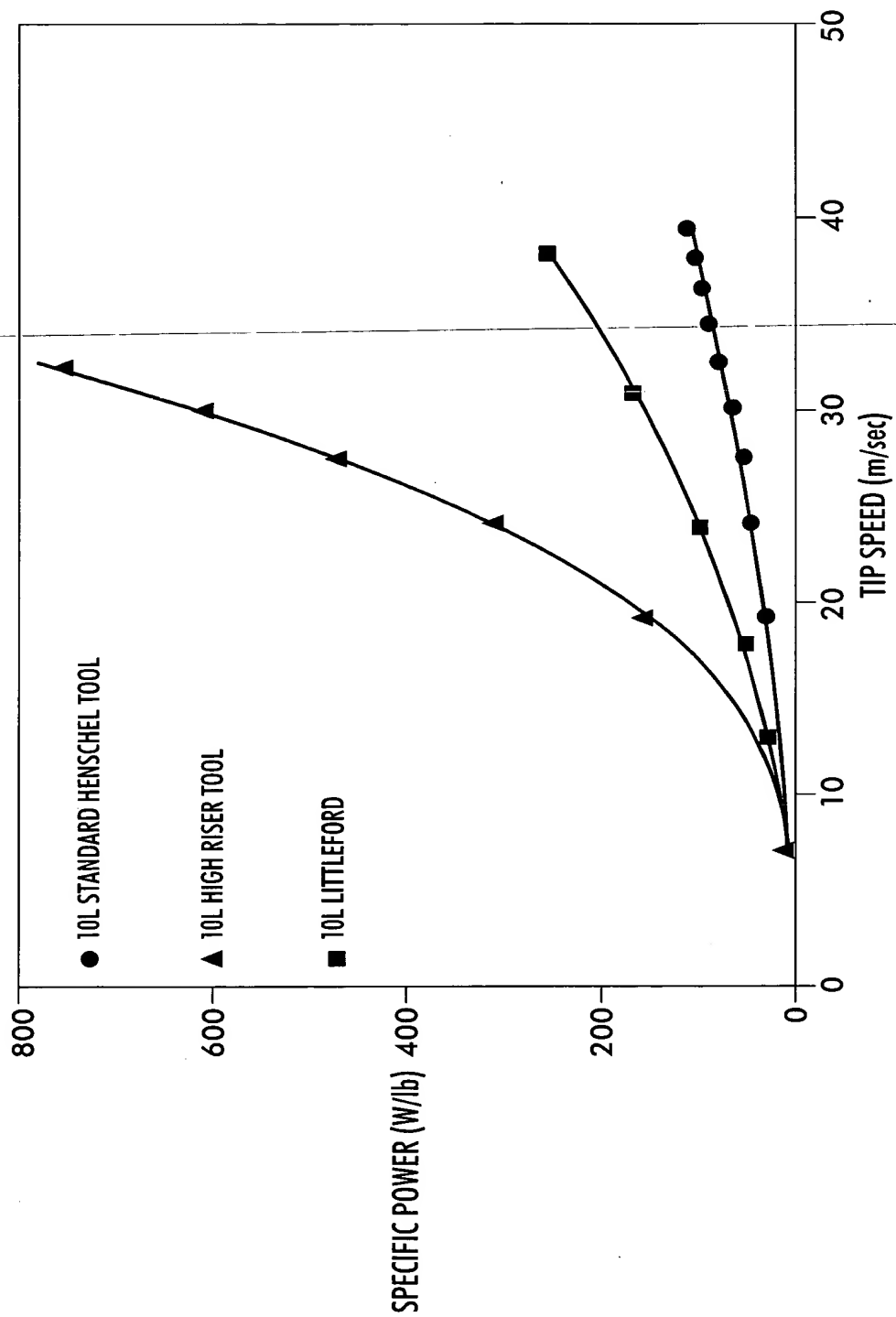


FIG. 9



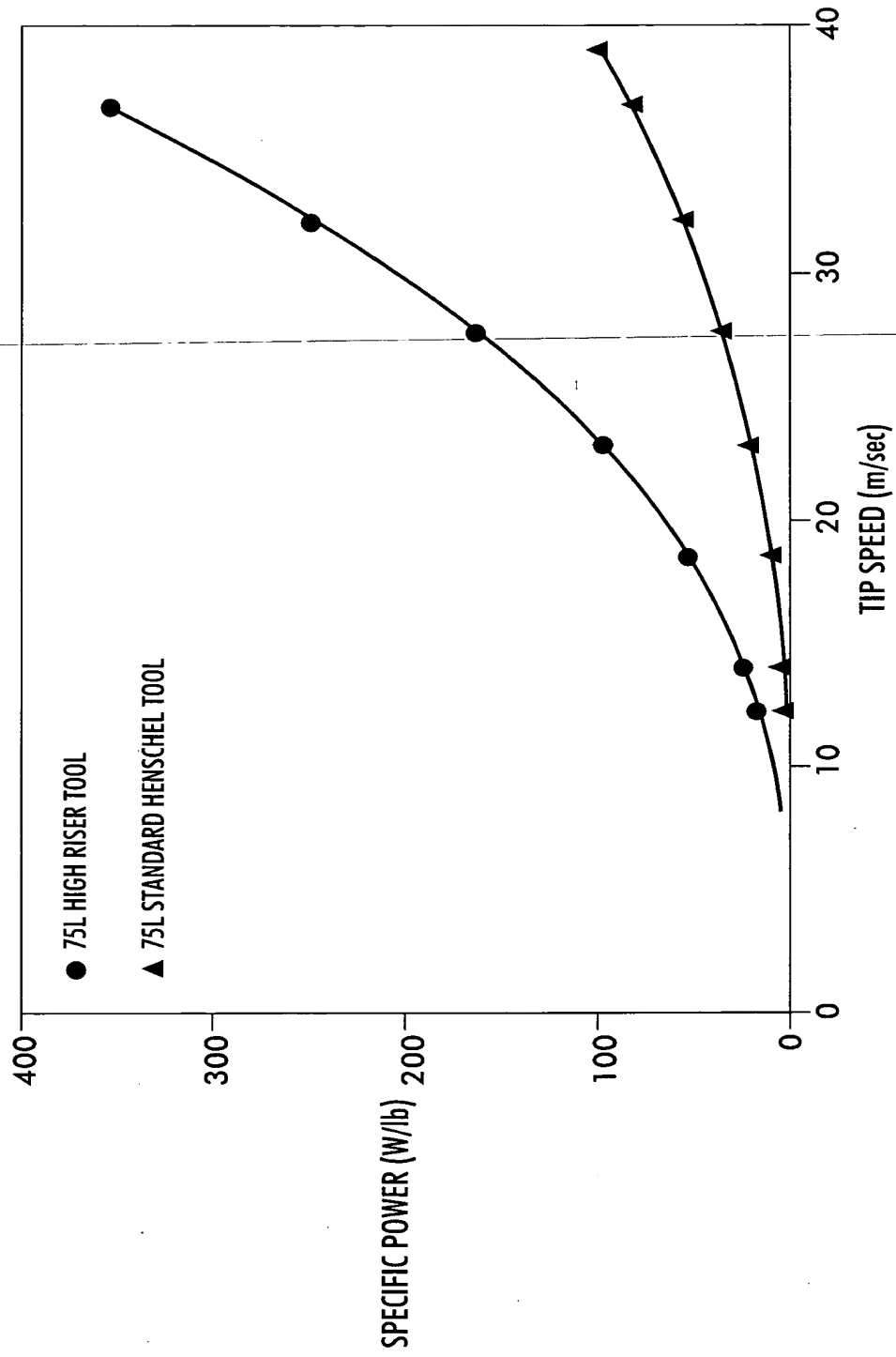


FIG. 10

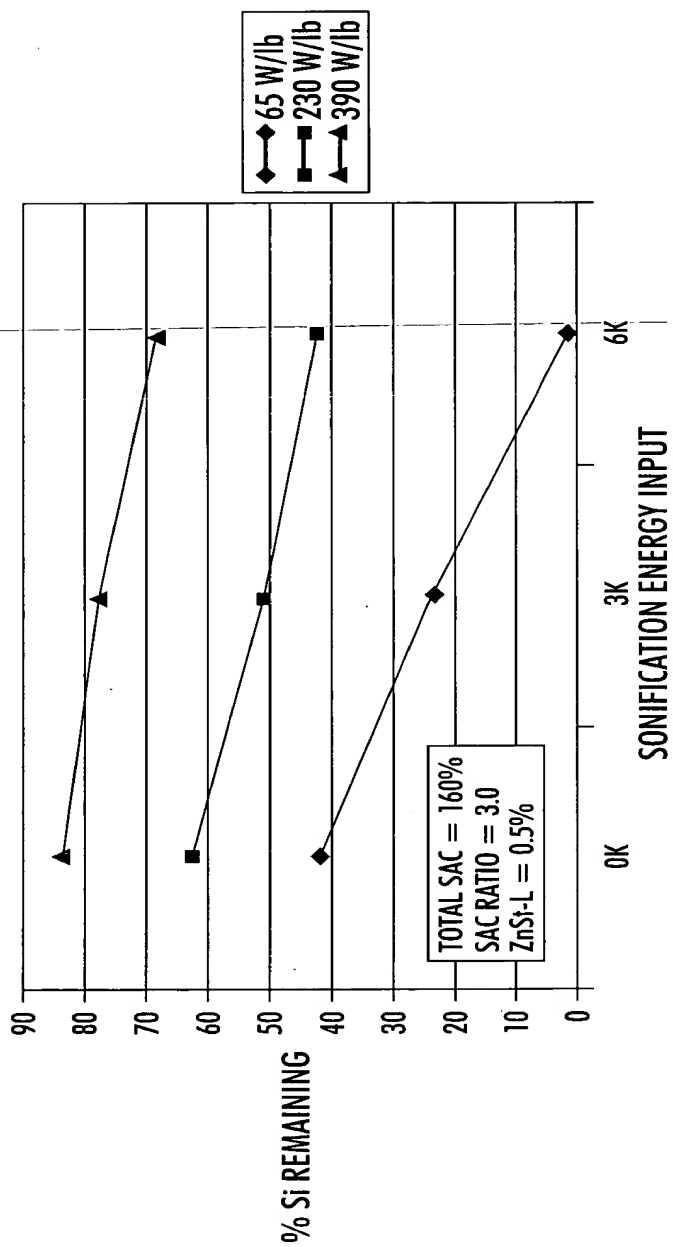


FIG. 11

TOTAL SAC = 160%

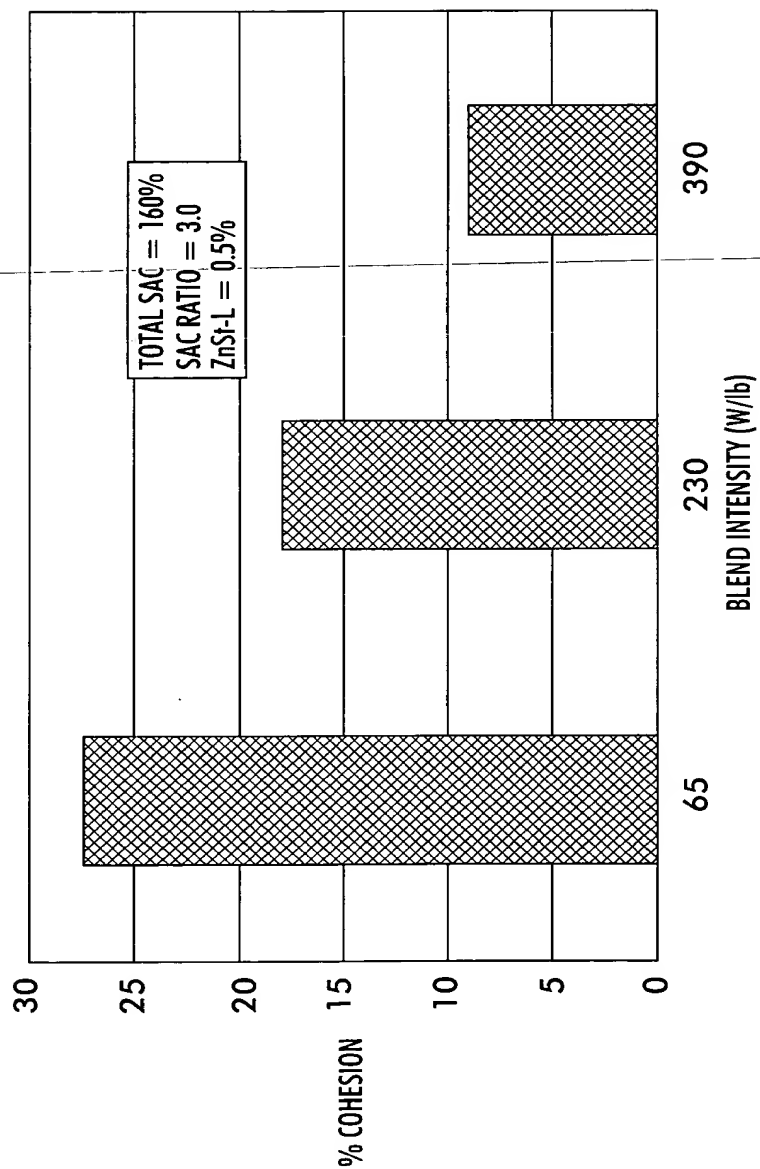


FIG. 12